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D4971-1
Job Sheet 187264



Part No: D4971-1

Job Qty: 10 ea

Part Name: T/R Bellcrank Cover



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/29/18

Job Tracking No:

Due Date: 12/13/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A 13.11.19 NEW ISSUE DD VERF:JLM IPP REV:B 14.04.01 PER DWG REV.A DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs		12/13/18	0.00	1.08	Waterjet - Flow		SC 18/12/09
110	QC	10 pcs		12/13/18	0.00	0.00	QC2 Waterjet-1		SC 18/12/09
120	QC	10 pcs		12/13/18	0.00	0.00	QC8-5		38
130	Brake NC	10 pcs		12/13/18	0.04	1.01	Brake NC 1		9-BB DAS 30
140	QC	10 pcs		12/13/18	0.00	0.00	QC5		38 9-89
150	HandFinish	10 pcs		12/13/18	0.00	0.60	HandFinish1		DR 18/12/20
160	QC	10 pcs		12/13/18	0.00	0.00	QC7-4		BR 18-12-20
170	Powdercoat	10 pcs		12/13/18	0.00	0.39	Powdercoat4		BR 18-12-20
180	QC	10 pcs		12/13/18	0.00	0.00	QC3		38
190	Packaging	10 pcs		12/13/18	0.00	0.00	Packaging3-2		21 9-89
200	QC21-SA	10 Ea		12/13/18	0.00	0.00	QC21		DEC 20 2018

M 138939 START 8:55 O.U.T. 320° FINISH 9:25

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.040	6061-T6 .040 Sheet	5.9000 sf (.59 ea)	100-Waterjet - Flow - 1	50120084

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.040	6	209	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	T/R Bell Crank Cover	0.098Inches + 0.004 - 0.001	0.102 0.097	0,100	
2	T/R Bell Crank Cover	0.201Inches + 0.005 - 0.001	0.206 0.200	0,205	
3	T/R Bell Crank Cover	0.330Inches ± 0.030	0.360 0.300	0,333	
4	T/R Bell Crank Cover	2.500Inches ± 0.010	2.510 2.490	2,505	
5	T/R Bell Crank Cover	0.520Inches ± 0.030	0.550	0,522	

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION		DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐	
	Use-as-is ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐	Quality ☐

Date : _____ Sequence #: _____

MRB (QSI042)

Description Work Order Devia _____

[Large empty area for description]	Completed By _____ d hand / Supervisor _____ QC / QA Coordinator _____
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DART Aerospace
 Container No: S135858
 Part: D4971-1
 Job No: 187264
 Serial No/Batch: S135858
 Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: Various STC's
 Date: 12/09/18

Root Cause			
Operator ☐	☐ Pl	☐	☐ Positioned Wrong
Manufacturing Process ☐	☐ B	☐	☐ Outside Tolerance
Equip/Tooling ☐	☐ Crushing	☐	☐ Drawing
Handling/Presservation ☐	☐ Cracks	☐ Broken/Damage/Corrosion	☐ Finish
Material ☐	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Part Lost/Missing
Product Improvement ☐	☐ Marks/Chatter	☐ Drill Holes	☐ Misread
Process Improvement ☐	☐ Mislabeled	☐ Fit/Function	
Human Factors ☐	Other/Details: _____		

			0.490	
6	T/R Bell Crank Cover	0.700Inches $\pm$ 0.030	0.730 0.670	0,707
7	T/R Bell Crank Cover	0.500Inches $\pm$ 0.030	0.530 0.470	0,502

Plex 11/29/18 11:13 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) _____	
Description Work Order Deviation			Disposition		
			Completed By _____		
			Lead hand / Supervisor _____		
			QC / QA Coordinator _____		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					